

SPLUT

PDF

Order ID 61881-2

y, September 08, 2010 3:27:17 PM



Page 1

Item ID: D4174-1

Accept



Setup

Start



Revision ID: PRELIM

Stop



Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

H

Date: 10.9.08 Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4174

PA1

0.00

100



Waterjet

FLOW CNC Waterjet

Memo

0.00

B10-4-13

1-Cut as per Dwg
Dwg Rev: PA1
Prog Rev: PA1

2-Deburr if necessary

(4)

110



QC2- Inspect parts off machine FAI/FAIB

0.00

QC

Memo

0.00

B10-4-13

Quality Control

Work Order ID 61881

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Item ID: D4174-1

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Setup Start



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Stop



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Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00 -S 10/05/13

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

BL 10-9-14.

④

φ

140



Powdercoat

Powder Coating

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

BL 10-9-16

Memo

Start Time:

Oven Temperature:

Finish Time:

1:50 320° 2:20

0.00

④

φ

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Setup

Start



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Stop



Item Name: Connector Plate

Start Date: 9/8/2010 Start Qty: 3.00



Cust Item ID:

Required Date: 9/13/2010 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC

Quality Control

QC3- Inspect Part Finish

0.00

→ M

10/09/06

X/ / 0

160



Packaging

Packaging

Identify as per dwg & Stock Location: *composites*

0.00

Memo

0.00

→ M
10/09/06

CT 10-10-01 K3

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/10/04 DJ

POSITIVE RECALL
 EFFECTIVE 10/09/06 AUTH h
 RELEASED 10/09/06 DATE 10/10/01
 PER RELEASED DMR
 DATED 10.09.06

PL 10-10-01
 3

Picklist Print

Wednesday, September 08, 2010 3:27:21 PM

Page 1

Work Order ID: 61881



Parent Item: D4174-1



Parent Item Name: Connector Plate

Start Date: 9/8/2010

Required Date: 9/13/2010

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP Rev:A 10.09.08 new issue verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063		Purchased	No			100	sf	104.9340	0.11	0.347368	145	1810-9-13	

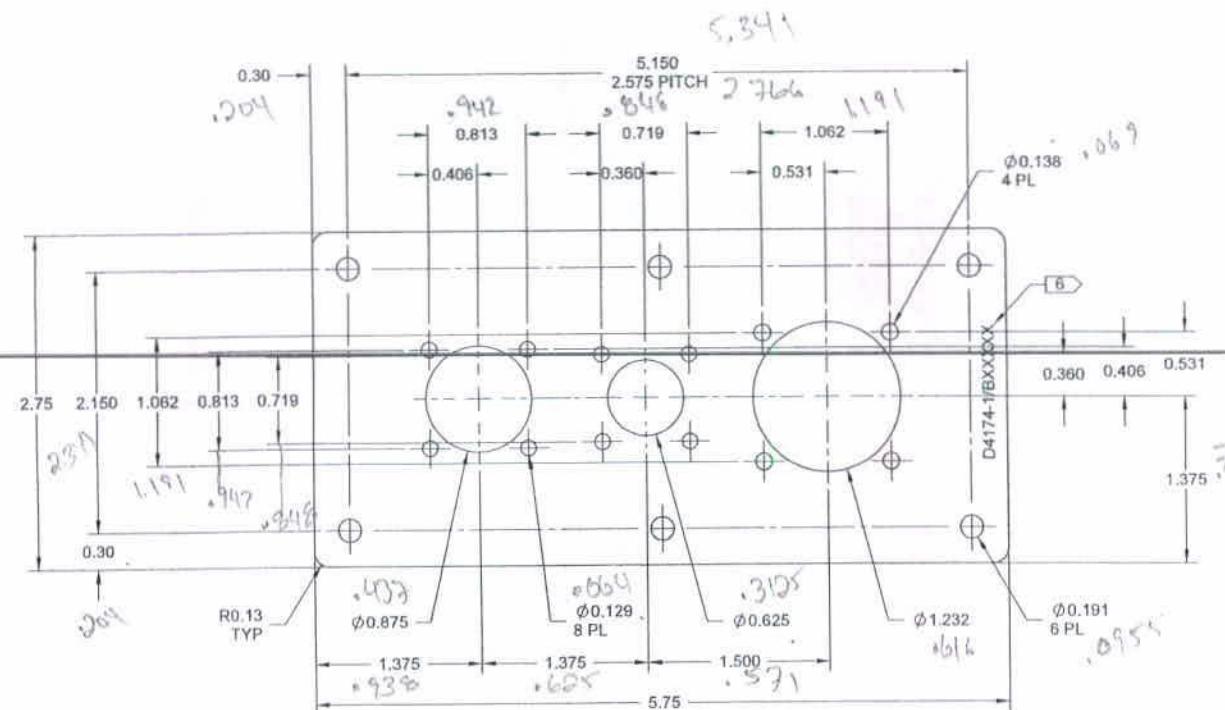
6061-T6-063 Sheet

Location	Loc Qty	Loc Code
MAT21	104.934	
113608	104.934	113608

(4)

Koute 1135m (1481')

✓
Done



D4174-1 CONNECTOR PLATE

PRELIMINARY ISSUE

10.09.0

NOTES:
1) MATERIAL: 6061-T61/T62 ALUMINUM SHEET, 0.063 THICK PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF. DART SPEC. M6061T6S.063
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE GLOSS" (4.3.5.1) PER DART QSI 005 4.3
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 0.08 lbs

PA1	NEW ISSUE	MB	10.09.01
REV.	1	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		DRAWING NO.	REV. PA1
CHECKED		D4174	SHEET 1 OF 2
MFG. APPR.		TITLE	SCALE
APPROVED		CONNECTOR PLATE	
DE APPR.		NTS	
DATE	10.09.01	COPYRIGHT © 2018 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD

Work Order: 61881

Description: CONNECTOR

Part Number: D4174-1

Inspection Dwg: D4174-1 Rev: P01

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

 First Article Prototype

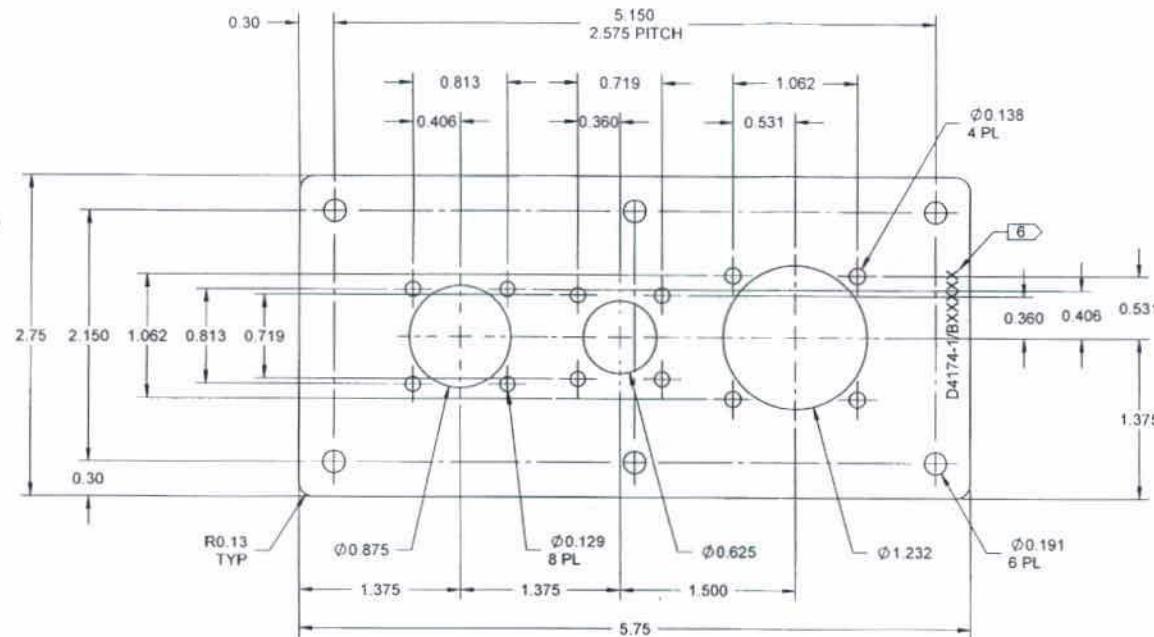
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø .129	+ .005 - .001	.131	+	*	V	HB07
Ø .138	+ .005 - .001	.139	+	*	V	
Ø .191	+ .005 - .001	.191	+	*	V	
Ø .675	+ .008 - .001	.676	+	*	V	
Ø .875	+ .010 - .001	.875	*	*	V	
Ø 1.233	+ .017 - .001	1.233	*	*	V	
.30	.7L .030	.300	*	*	V	
.5150	.7L .010	.5149	*	*	V	
.5575	.7L .010	.5574	*	*	V	
.813	.7L .010	.810	*	*	V	
.719	.7L .010	.717	*	*	V	
1.067	.7L .010	1.067	*	*	V	
.406	.7L .010	.404	*	*	V	
.366	.7L .010	.360	*	*	V	
.531	.7L .010	.532	+	*	V	
1.375	.7L .010	1.375	+	*	V	
1.500	.7L .010	1.500	*	*	V	
.575	.7L .030	.5747	*	*	V	
2.150	.7L .010	2.146	*	*	V	
2.75	.7L .030	2.749	*	*	V	
.063	.7L .010	.064	*	*	V	

Measured by:	IB
Date:	10-9-13

Audited by:	S
Date:	10/09/13

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



D4174-1 CONNECTOR PLATE

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6) IDENTIFICATION: PER QSI 044 6.1

7) WEIGHT: 0.08 lbs

61881

RELEASED
2010-09-29
AM

A	NEW ISSUE	MB	10.09.01
REV.	DESCRIPTION		
DESIGN	<i>1</i>	BY	DATE
DRAWN	<i>2</i>	DART AEROSPACE LTD	
CHECKED	<i>3</i>	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	<i>4</i>	DRAWING NO.	REV. A
APPROVED	<i>5</i>	D4174	SHEET 1 OF 2
DE APPR.	<i>6</i>	TITLE	SCALE
DATE	10.09.01	CONNECTOR PLATE	
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